

Date: Tuesday, 06/05/2008 3:48:47 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD X-TUBE EXT HEIGHT(-013)
Job Number :	39077		
Estimate Number :	10565		
P.O. Number :		Part Number :	D205596105
This Issue :	06/05/2008	Drawing Number :	D205596105
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1 /	Drawing Revision :	B
Previous Run :	39076	Material :	
Written By :		Due Date :	13/05/2008
Checked & Approved By :	JLD 08.5.08	Qty:	1 Um: Each
Comment :	Est Rev:D 05.03.21 Added bending procedure KJ/JLM Est Rev:E 08-01-10 ECN 1075 DD Est Rev F 08.04.28 Added bending & mat'l EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.5.08



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG002

2.0	D6005180	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

batch: B38345

DP 8-8-14

3.0	BENDING CROSS	BENDING MACHINE - CROSSTUBES
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Comment: BENDING MACHINE - CROSSTUBES

Bend as per Dwg D2889 using CNC bender program

DP 8-8-14

4.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

DP 8-8-14

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

106-06-18 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:48:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 39077

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-105

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

AWM 5-8-16

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

06-08-18 (1)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

SE-8-18

Chemical Conversion Coat per QSI 005 4.1

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

ml 08 08 19

(1)

10.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

85 08-08-20

11.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION

batch 38500

ml 08 08 20

12.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp(per MIL-DTL-8783C)

batch 108974

ml 08 08 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:48:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 39077

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D28931

2.75 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2893-1

Support

38124

ml 08 08 20

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-105

Magnobond 6398 Batch: 107621

EXP: 08/2009 time: 12:35 pm

3- Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb. as per dwg

ml 08 08 20 (1)

ml 08 08 21 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/21 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-105

Location:

PPP Rev:

Rev D

08/08/22

(1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22 (1)

Job Completion



u 08/08/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

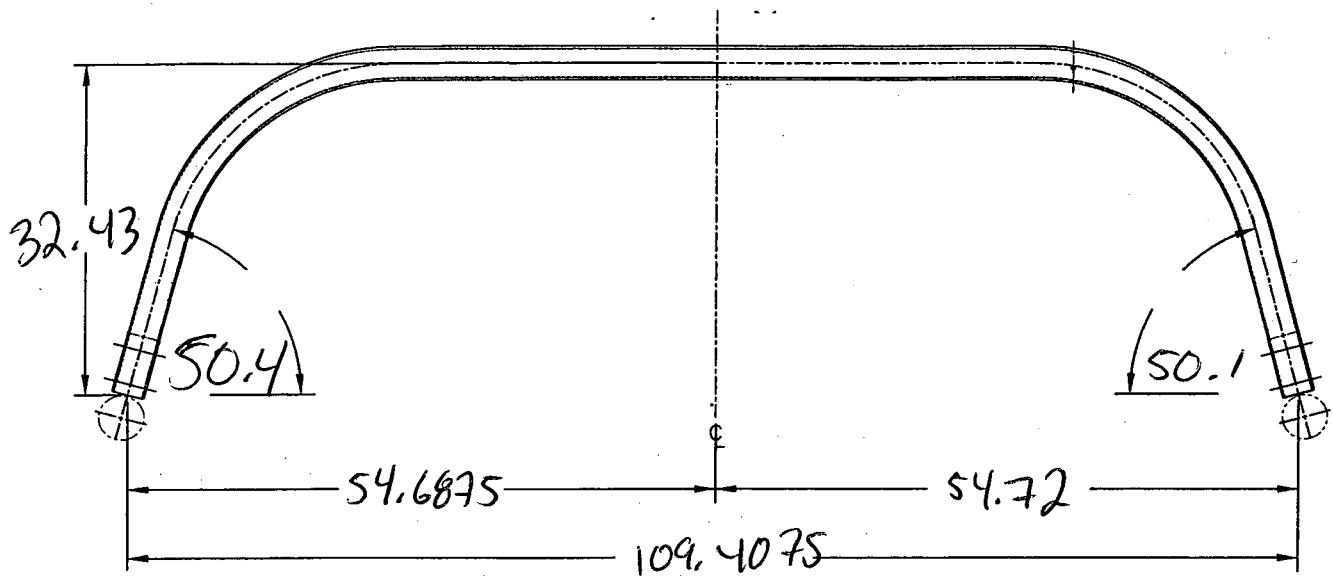
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39077
Description: Crosstube High-High Fwd		Part Number:	D205-596-105
Inspection Dwg: D205-596-105 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6



Comments

QC15 Inspection	<i>[Signature]</i> 06.06.10
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>
B	08.04.21	Dwg Rev updated	KJ/JM	

PARTS LIST:

Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

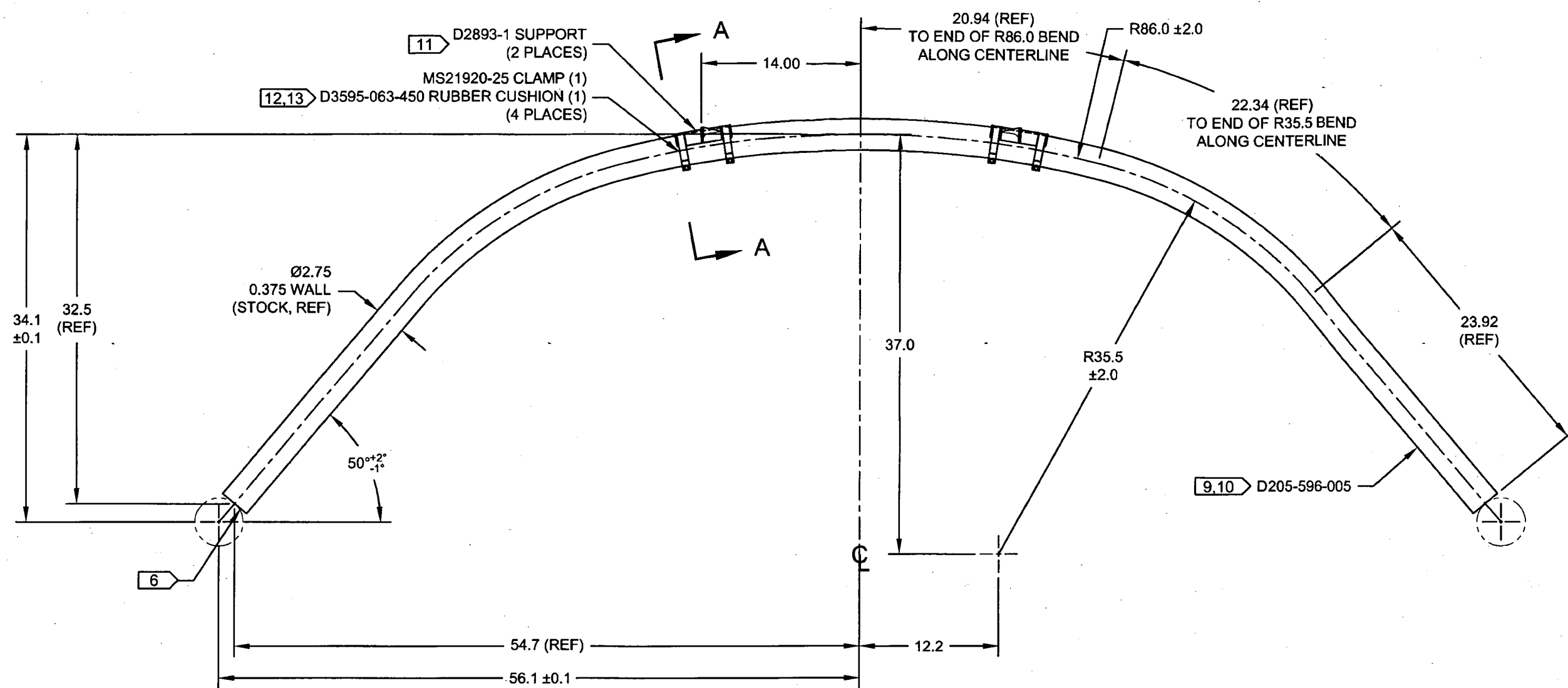
- 1) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 134.40 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR
SHORTER (MS21920-24) CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

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WITHOUT NOTICE
WORK ORDER
NO. 39077

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06-01-16 W

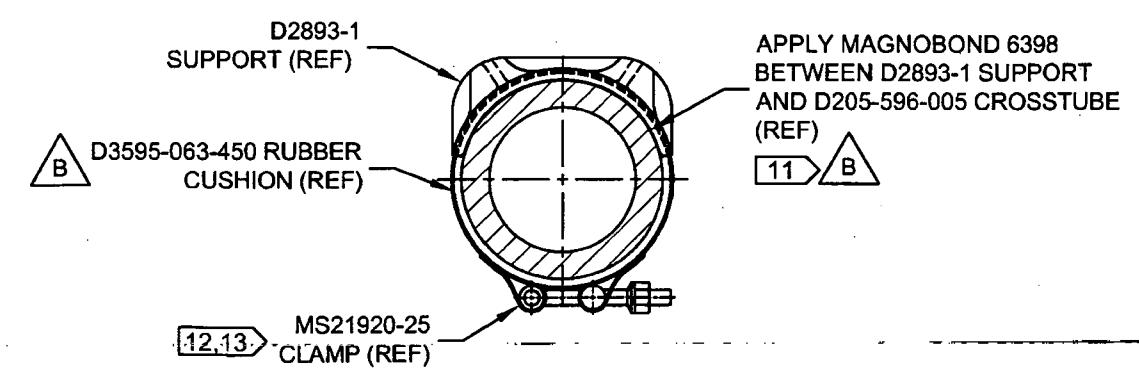
B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	BE	D205-596-105	SHEET 1 OF 2
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DE APPR.	TH	CROSSTUBE ASSEMBLY, HI-HI FWD	NTS
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D205-596-105 CROSSTUBE ASSEMBLY, HI-HI FWD

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SECTION A-A
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D205-596-105	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI FWD	1:10
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